

7-4 0.750

Work Order ID 164239

164239

Friday, July 14, 2017 12:43:17 PM

Item ID: D3407-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Stem

Start Date: 7/18/2017 Start Qty: 40.00 *40* Cust Item ID:
Required Date: 7/26/2017 Req'd Qty: 40.00 *40* Customer:

Reference: D.S.
21
9-29

Approvals: Process Plan: _____ Date: JUL 14 2017 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3407	Rev E

100 DOOSAN LATHE 0.95
100
Doosan Memo 4.78
Doosan Lathe 1-Turn as per Folio FA597 Rev. 1/14 & Dwg D3407 Rev: E

Mill slot width at max tolerance .260"
2-Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.80
Quality Control

40 417-30

417-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Work Order ID 164239

Friday, July 14, 2017 12:43:17 PM

164239

Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 44 9-29-17-07-31
120						40	0		
QC	Memo	0.80							
Quality Control									
130	Identify as per dwg & Stock Location: WA001	0.00							DAS 6 JUL 31 2017
130									
Packaging	Memo	4.00							
Packaging	LOCATION: WA001								
140	QC21- Final Inspection - Work Order Release	0.00							17/8/2
140									
QC	Memo	0.40							
Quality Control									

 JUL 31 2017

Picklist Print

Friday, July 14, 2017 12:43:19 PM

Page 1

Work Order ID: 164239

164239

Parent Item: D3407-3

D3407-3

Parent Item Name: Stem

Start Date: 7/18/2017

Required Date: 7/26/2017

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.10.18New issueKJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750		Purchased		No		100	f	42.7451	0.366	15.41053			

M174R0 750

17-4 round bar .750

**

SLIT-730

Location

Loc Qty

Loc Code

MAT

42.7451

m133265

0.0001

m135232

5.345

m137762

13.4

m137823 12+

24

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DART AEROSPACE LTD		Work Order: 164239
Description: Stem		Part Number: D3407-3
Inspection Dwg: D3407 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

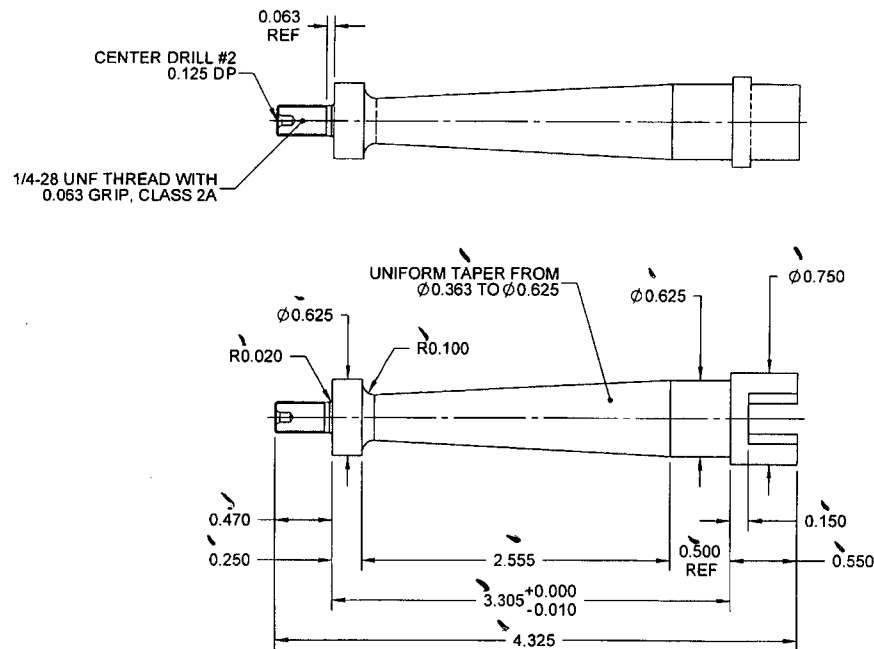
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.07	/			
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	/			
Major Ø	Max: 0.249 Min: 0.2425	.247	/			
Ø0.625	+/-0.010	.625	/			
Ø0.363	+/-0.010	.364	/			
Ø0.750	+/-0.010	.751	/			
R0.100	+/-0.010	R.100	/			
0.470	+/-0.010	.472	/			
0.250	+/-0.010	.247	/			
2.555	+/-0.010	2.550	/			
3.305	+0.000/-0.010	3.297	/			
4.325	+/-0.010	4.328	/			
0.150	+/-0.010	.154	/			
0.550	+/-0.010	.555	/			
0.625	+/-0.010	.625	/			
0.250	+0.010/-0.000	.259	/			

DAS

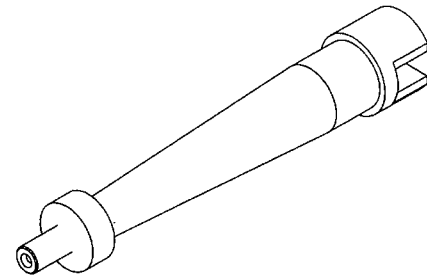
Measured by: [Signature]	Audited by: 44 9-89	Prototype Approval:	N/A
Date: 17-7-30	Date: 17-07-31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD [Signature]	[Signature]



D3407-3 STEM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164239 MCO
170714



- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

RELEASED
08-03-01 RLB

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	